

Date: Wednesday, 28/02/2007 11:04:39 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: DOUBLER
Job Number	: 30987		
Estimate Number	: 10804		
P.O. Number	: <i>NIA</i>	Part Number	: D3578041
This Issue	: 28/02/2007	S.O. No.	: <i>NIA</i>
Prsht Rev.	: NC	Drawing Number	: D3578 REV.A-PRELIM.
First Issue	: <i>NIA</i>	Project Number	: <i>NIA</i>
Previous Run	: 00015	Drawing Revision	: <i>NIA</i>
		Material	: <i>NIA</i>
Written By	: <i>[Signature]</i>	Due Date	: 07/03/2007
Checked & Approved By	: _____	Qty:	8 Um: Each
Comment	: _____		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 make D3578-1 per dwg D3578 Rev.A	
2.0	M6061T6S080	6061-T6 .080 Sheet
	Comment: Qty.: 0.0100 sf(s)/Unit Total : 0.0800 sf(s) 6061-T6 .080 Sheet <i>M101178</i> <i>070228</i>	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 deburr <i>070228</i> <i>8</i>	
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 install nutplates & rivets per dwg D3578 rev.A <i>070301</i> <i>8</i>	
5.0	MS21075L3	Nutplate
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Nutplate <i>M18534</i> <i>070301</i> <i>8</i>	

Date: Wednesday, 28/02/2007 11:04:39 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: DOUBLER

Job Number: 30987

Part Number: D3578041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	MS20426AD33	Rivet
-----	-------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
Rivet

M 7681

[Signature]

070301

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

[Signature] 0703-01

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
acid etch & alodine

[Signature]

070301

8

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

[Signature] 0708-01

10.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
ID & STK

charge to w/o 00064

[Signature]

070302

8

11.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

[Signature] took
project

070305

Job Completion



U 07-03-05

NOTE: FOR PROPER FIT, PARTS REQUIRED TO BE MODIFIED
AS PER MARKED UP DRAWINGS UPON INSTALLATION.
RECOMMEND REVISING DIMS ACCORDINGLY.

[Signature] 07-03-02

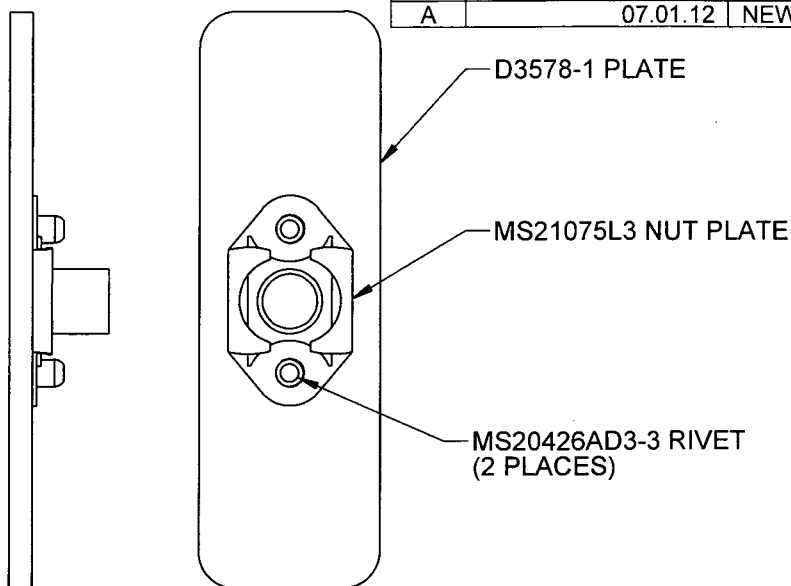
PRELIMINARY ISSUE

Grommet - D3596-1
Tool D3603-1

UNDER REVIEW

07.02.28 LE

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12	TITLE DOUBLER		SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	



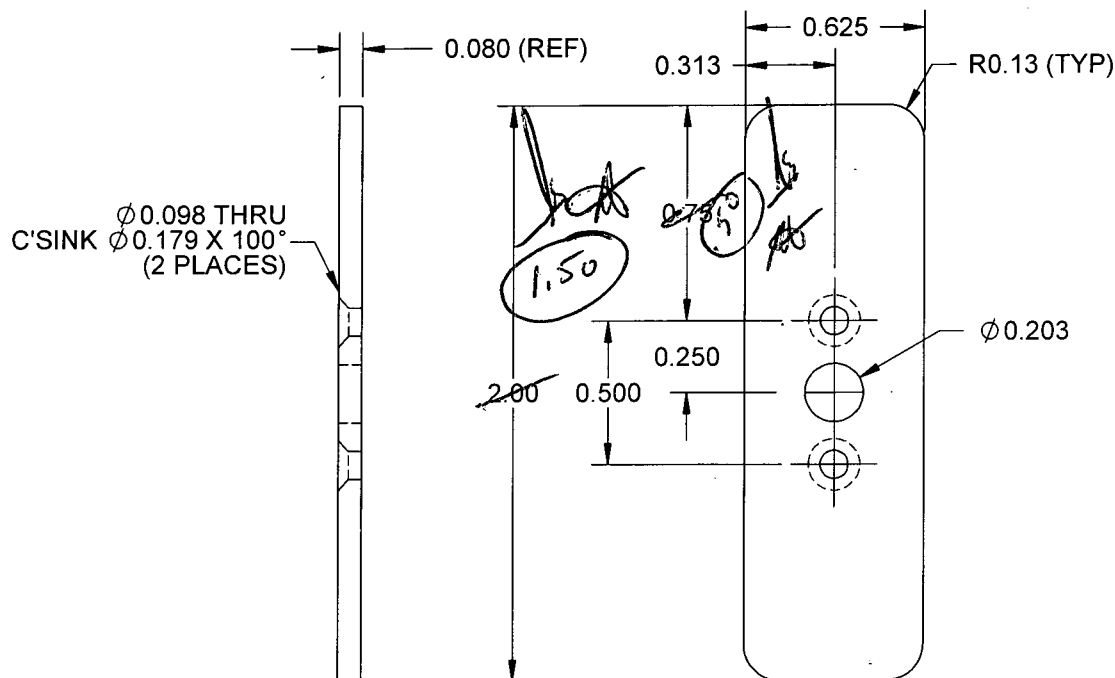
D3578-041 DOUBLER

D3578-041 PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 NOTES:

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER



D3578-1 PLATE

D3578-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62)ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX


COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

Measured by:	
Date:	070228

Audited by:	<i>[Signature]</i>
Date:	01.01.78

Prototype Approval:	LE
Date:	07.03.15

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	